

Monday, March 14, 2011 2:00:07 PM

Page 1



Accept

**Setup Start**

Revision ID:

Stop



Item Name: Rib

Start Date: 3/14/2011 **Start Qty:** 6.00

**Cust Item ID:**

Required Date: 3/18/2011 **Req'd Qty:** 6.00



Customer:

Reference:

Run Start



Approvals: **Process Plan:**

Date: 11-03-14

Tooling:

Date:

Stop






QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4034	B								
100		0.00							
									
Large Fab	Memo	0.00							
Large Fab	1- Cut tube as per dwg D4034								
			SAD	11-03-22			(28)		
110	QC6- Inspect dimensions to drawing	0.00							
									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
									
Packaging	Memo	0.00							
Packaging									
			SAD	11-03-23			(28)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67271

Page 2

Monday, March 14, 2011 2:00:07 PM

Item ID: D4034-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 3/14/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/23

H11-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 14, 2011 2:00:13 PM

Page 1

Work Order ID: 67271

Parent Item: D4034-1

Parent Item Name: Rib



Start Date: 3/14/2011

Required Date: 3/18/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.18 chg
qc5 to 6 DD verf:EC IPP Rev:D 11.01.19 AS PER DWG
REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased	No			100	f	224.8708	0.3333	2.105053			
304 SQ Tube .75x.75x.049W													

Location	Loc Qty	Loc Code
MAT	206.8670209	
113763	0	
114323	8.15031894	
114677	0.00001	
114835	0.000039	
116319	7.2604	
116509	12.4739	
116719	2.418053	
116788	23.2148	
117029	153.3495	
MAT017	3.68448E-05	
114298	3.6845E-05	
WA	18.0037	
114992	8.8798	
115260	9.1239	

21 7.3679 + 0.7825 = 8.1504
 END Scrap
 2.4563 + 2.000 = 4.4563
 total 2.6072

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

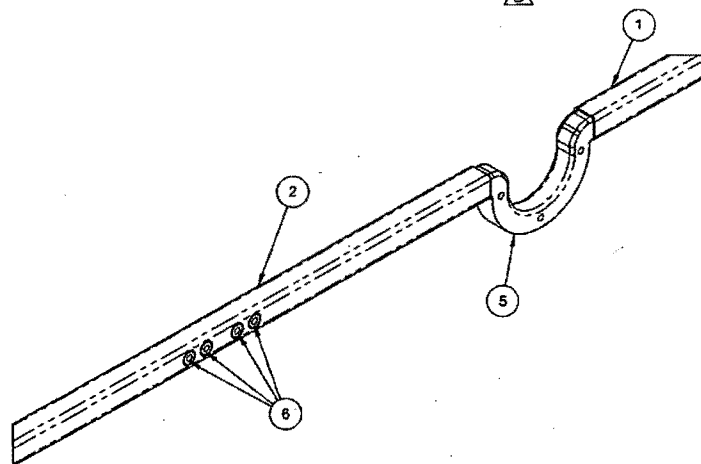
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

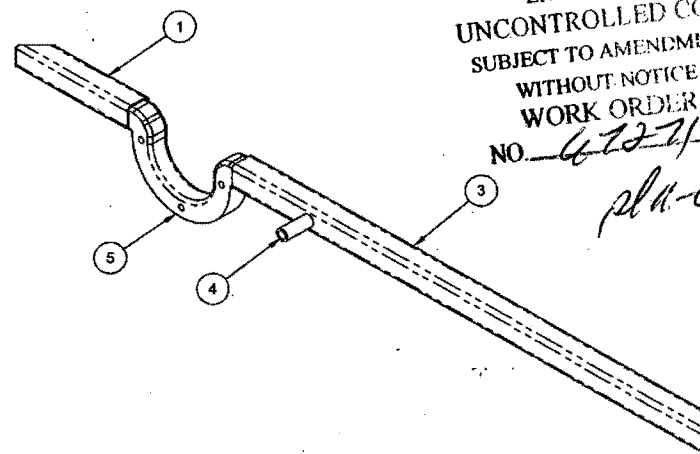
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



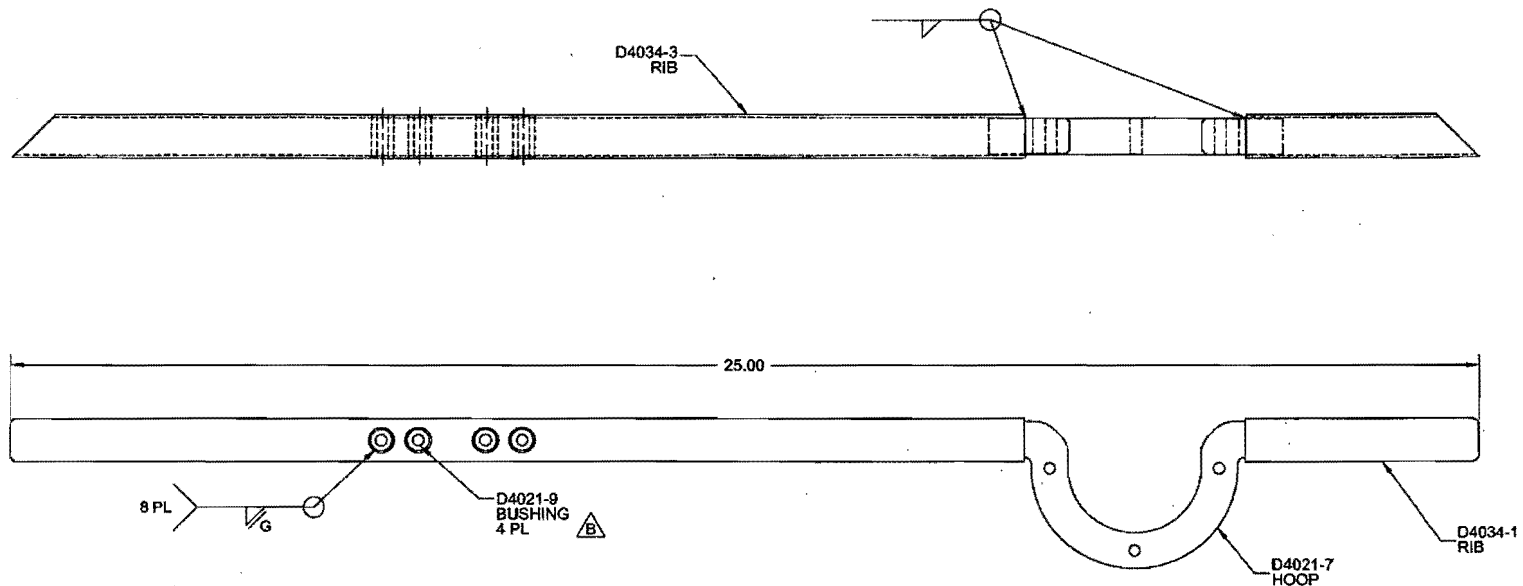
D4034-043 FWD UPPER RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67271

pln-03-14

RELEASED
2011-01-18
JM

B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	UPPER RIB ASSY, BASKET BASE	NTS
DATE	10.12.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL, AND IS CONTROLLED ON THE BASIS OF THE INFORMATION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4034-041 AFT UPPER RIB ASSY

12067271

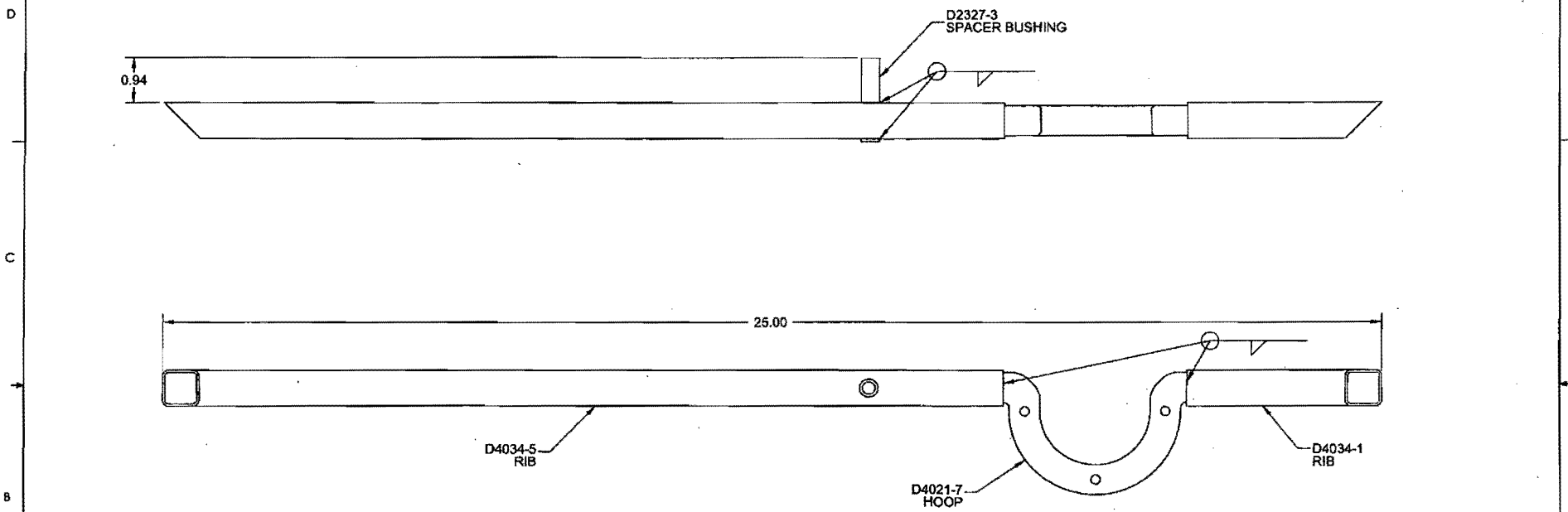
RELEASED
2011-01-28

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	AD	D4034	SHEET 2 OF 4
APPROVED	AD	TITLE	SCALE
DE APPR.	AD	UPPER RIB ASSY, BASKET BASE	NTS
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8 7 6 5 4 3 2 1



D4034-043 FWD UPPER RIB ASSY

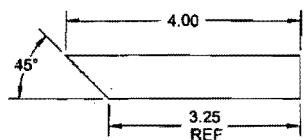
w/047271

RELEASED
2011-01-18

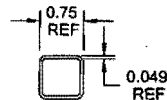
- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.58 lbs
 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Is	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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8 7 6 5 4 3 2 1



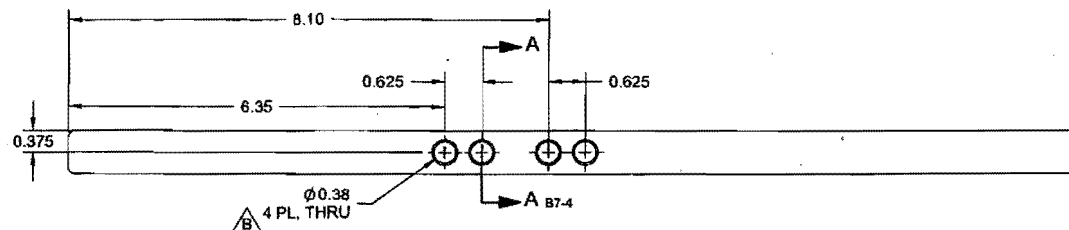
D4034-1 RIB



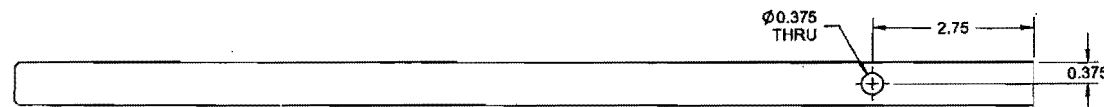
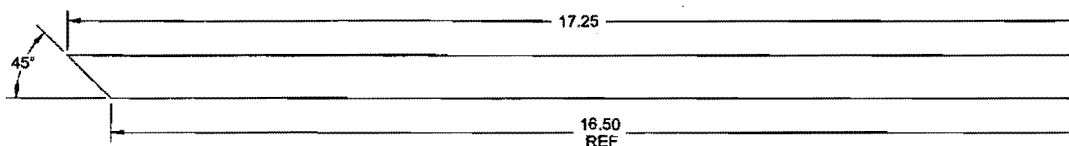
BREAK EDGE
0.030 X 45°
TYP



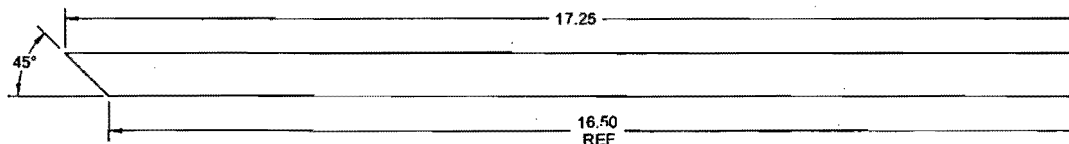
SECTION A-A D44



D4034-3 RIB



D4034-5 RIB



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

w/047271

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LS	DRAWING NO.	REV. B
MFG. APPR.	TS	D4034	SHEET 4 OF 4
APPROVED	TS	TITLE	SCALE
DE APPR.	TS	UPPER RIB ASSY, BASKET BASE	NTS
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2011-01-10

